

Date: Tuesday, 08/04/2008 4:56:59 PM
 Ver: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT X-TUBE EXT HEIGHT GEAR
Job Number :	38486		
Estimate Number :	10421		
P.O. Number :		Part Number :	D205596103
This Issue :	08/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D205-596-103
First Issue :	//	Project Number :	N/A
Previous Run :	37942	Drawing Revision :	B
	Type :	Material :	
	LANDING GEAR	Due Date :	30/05/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	JB 08.4.09		
Comment :	Est Rev:G 05.06.10 Acid etch moved to Step 11 KJ/JLM Est RevH 08-01-10 ECN 1075 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Photocopy D205-594 bluefile & type labels per PPP D205-596-103 CHG002

JLD 08.4.22

2.0	D2890	Aft Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2890	Aft Crosstube	B38666

DP 8-7-23

3.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

DP 8-7-23

1-Mark 37.30" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

10607-23 ①

5.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-103

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

Arm 8-7-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:56:59 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT GEAR

Job Number: 38486

Part Number: D205596103

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

Sos/g/24 (x0)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

TOUCH UP Chemical Conversion Coat as per QSI 005 4.1

AWMS-24

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sos/g/24 (x0)

9.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

2T 08-07-29

10.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

2T 08-07-30 (x0)

11.0

D3595063530

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RUBBER CUSHION

batch 39255

2T 08-07-30

12.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch 107502

2T 08-07-30

13.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

2 D2940-1

Description

Support 39390

Batch

2T 08-07-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:56:59 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT GEAR

Job Number: 38486

Part Number: D205596103

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2- Apply magnobond 6398 as per dwg D205-596-103

Magnobond 6398 Batch: 4107621

EXP: 09-02-01

3- Install supports and clamps per Dwg D205-596-103. Torque clamps to 80-100 in lb. as per dwg

FT 08-07-30

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/31 (XL)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-103

Location: 6

P 8/7/31 (1)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/31

Job Completion



MF 08-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

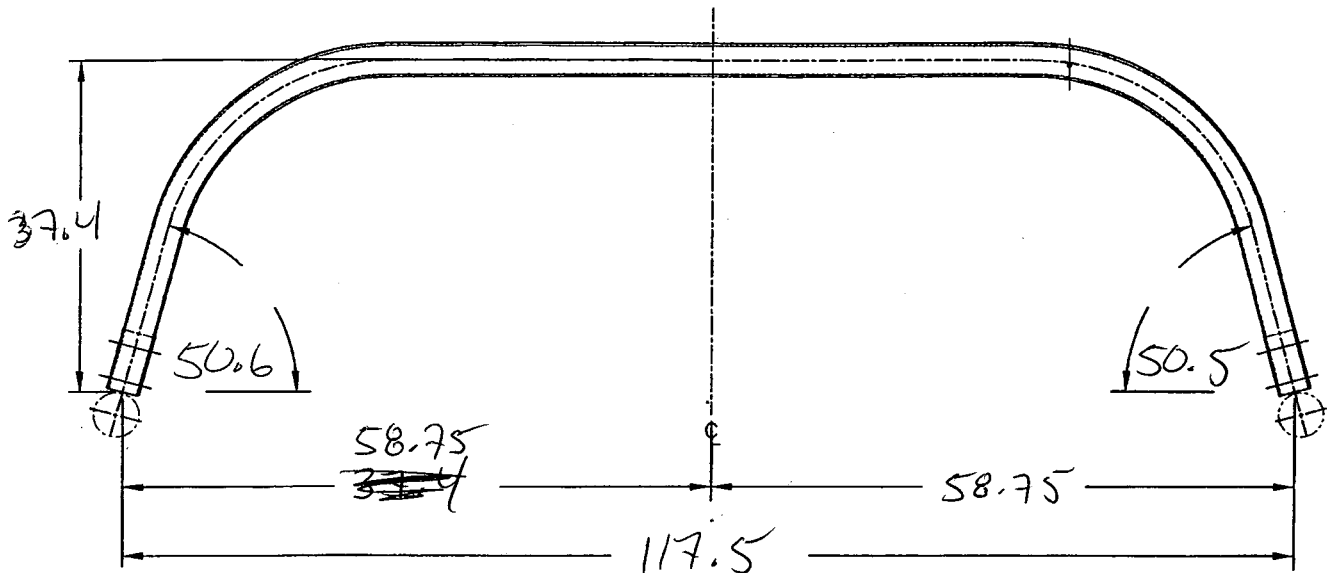
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38484
Description: Crosstube High-High Aft		Part Number:	D205-596-103
Inspection Dwg: D205-596-103	Rev: A B		Page 1 of 1

208-04-09

Required Dimension	Min	Max
Height	37.2	37.4
1/2 Span	58.7	58.9
Angle	49	52
Total Span	117.4	117.8



Comments

QC15 Inspection	
Date	08-07-08

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

PARTS LIST:

Qty	Part Number	Description
X	D205-596-103	CROSSTUBE ASSEMBLY, HI-HI AFT
1	D6008-180	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURE FROM D6008-180
FINISHED LENGTH = 146.98 ± 0.02
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH
VIBRATING STYLUS
- 7) WEIGHT: 55 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE
CROSSTUBE SUPPORT.
**NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-28 CLAMPS WITH LONGER OR SHORTER
MS21920-XX CLAMPS TO ACCOMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF
1.5 THREADS IN SAFETY ON THE NUTS.**
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38486

B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-1009 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-530 CUSHION	MB	07.12.03
A	NEW ISSUE	DS	02.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D205-596-103	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE ASSEMBLY, HI-HI AFT	NTS
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